

Date: Thursday, 5/4/2006 11:13:20 AM
 User: Kim Johnston

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : COVER PLATE ASSEMBLY, RH |
| Job Number : 26950 | |
| Estimate Number : 12302 | |
| P.O. Number : N/A | Part Number : D3467048 |
| This Issue : 5/4/2006 S.O. No. : N/A | Drawing Number : D3467 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 26605 | Material : N/A |
| Written By : <u>See</u> <u>LA COMMENT Below</u> | Due Date : 5/28/2006 |
| Checked & Approved By : <u>KJ 06.05.05</u> | Qty: <u>2</u> 8 Um: Each |
| Comment : Est Rev: A New Issue 06-04-24 EC | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|----------------|
| 1.0 | D34672 | COVER PLATE RH |
|-----|--------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|--------------|----------------|
| 1 | D3467-2 | Shourd Plate | <u>B 26988</u> |

| | | |
|-----|--------|------------|
| 2.0 | D34677 | SEAL STRIP |
|-----|--------|------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|----------------|
| 1 | D3467-7 | Doubler | <u>B 26983</u> |

SP 06/06/02 (2)

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-048

SP 06/06/03 (2)

| | | |
|-----|-------|-----------------|
| 4.0 | QC5/9 | WELD INSPECTION |
|-----|-------|-----------------|



Comment: WELD INSPECTION

06.06.05 (2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 19 Date: 06/06/07
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:13:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER PLATE ASSEMBLY, RH

Job Number: 26950

Part Number: D3467048

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 447

6/6/5 (2)

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/06 (2)

Job Completion



W. Decker

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

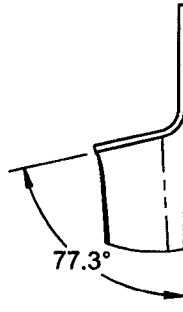
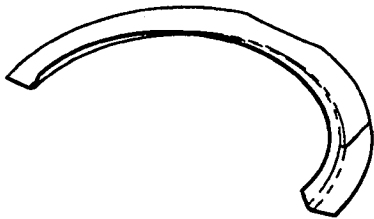
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

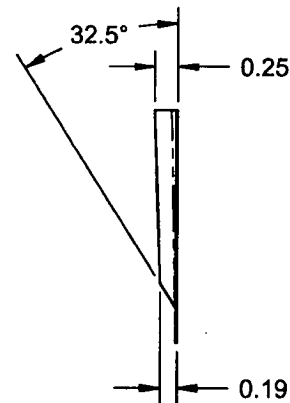
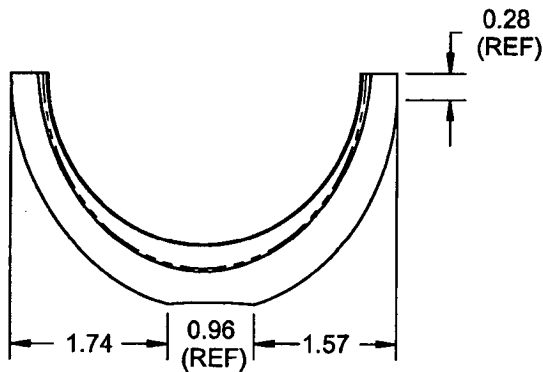
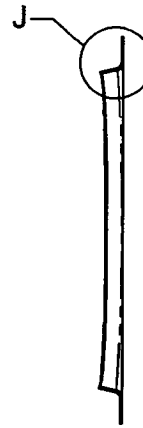
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3467 | REV. A SHEET 15 OF 15 |
| DATE 05.12.07 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |

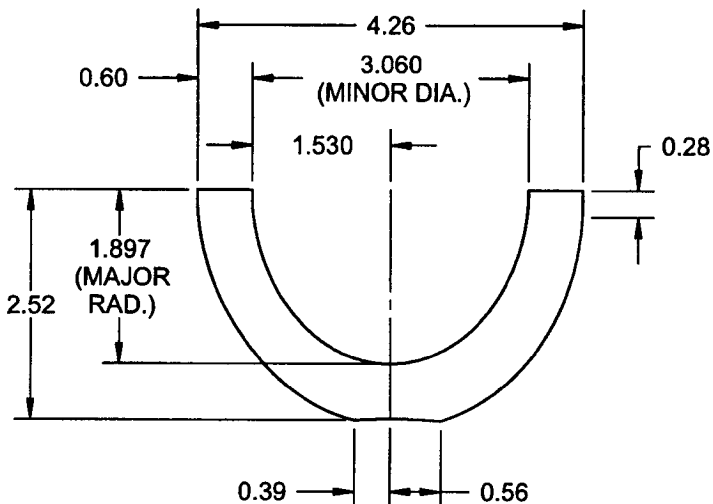
RELEASED
06.04.03 *[Signature]*



DETAIL J
SCALE 1:2



D3467-19 DOUBLER, L/H SHOWN
D3467-20 DOUBLER, R/H OPPOSITE



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D3467-19F FLAT PATTERN

NOTES:

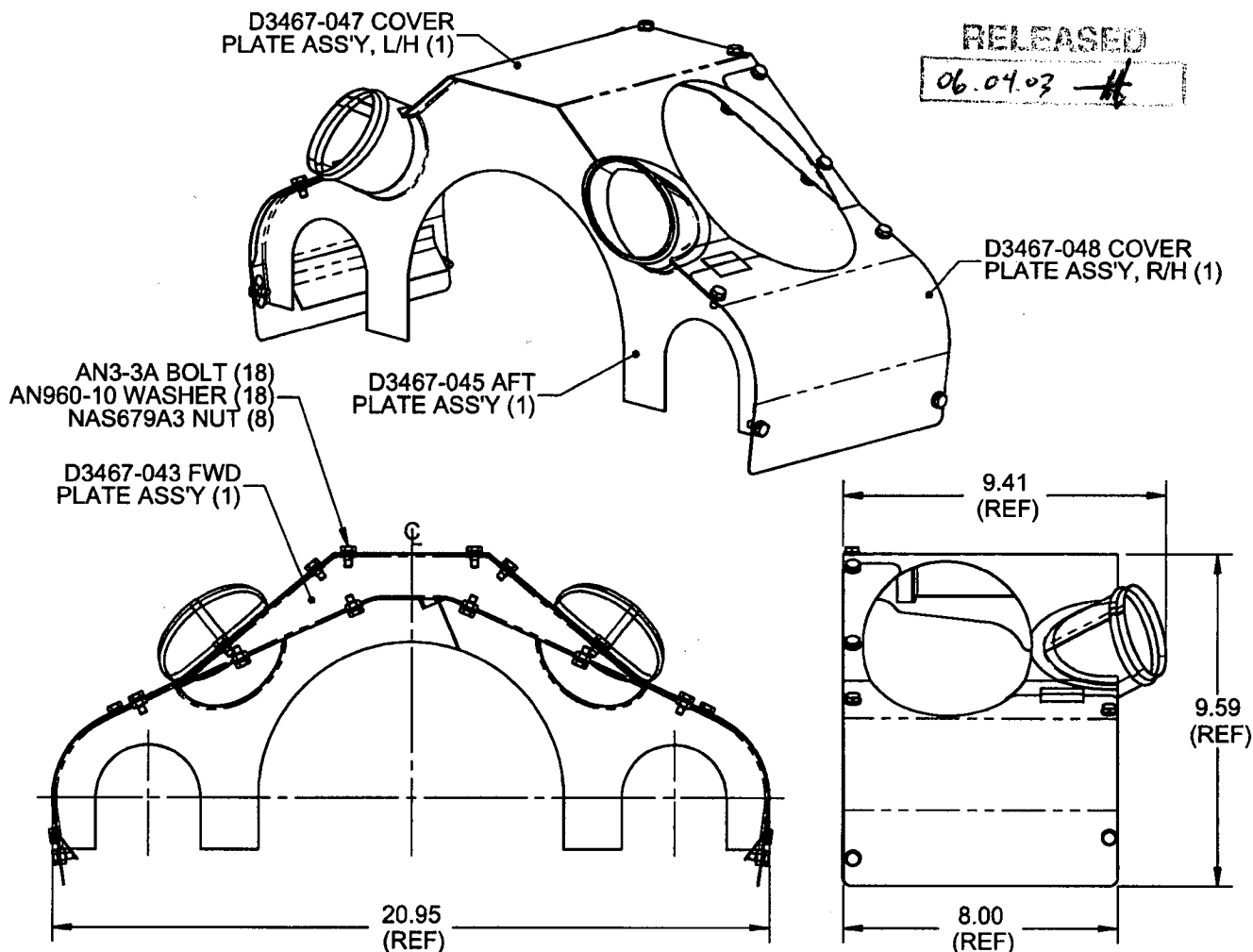
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| DATE 05.12.07 | | TITLE SHROUD ASSEMBLY | SCALE 1:5 |
| A | 05.12.07 | NEW ISSUE | |



D3467-041 SHROUD ASSEMBLY

NOTES:

- 1) IDENTIFY WITH DART P/N D3467-041 USING FINE POINT PERMANENT INK MARKER
- 2) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|--------------------------|
| X | D3467-041 | SHROUD ASSEMBLY |
| 1 | D3467-043 | FWD PLATE ASSEMBLY |
| 1 | D3467-045 | AFT PLATE ASSEMBLY |
| 1 | D3467-047 | COVER PLATE ASSEMBLY L/H |
| 1 | D3467-048 | COVER PLATE ASSEMBLY R/H |
| 18 | AN3-3A | BOLT |
| 18 | AN960-10 | WASHER |
| 8 | NAS679A3 | NUT |

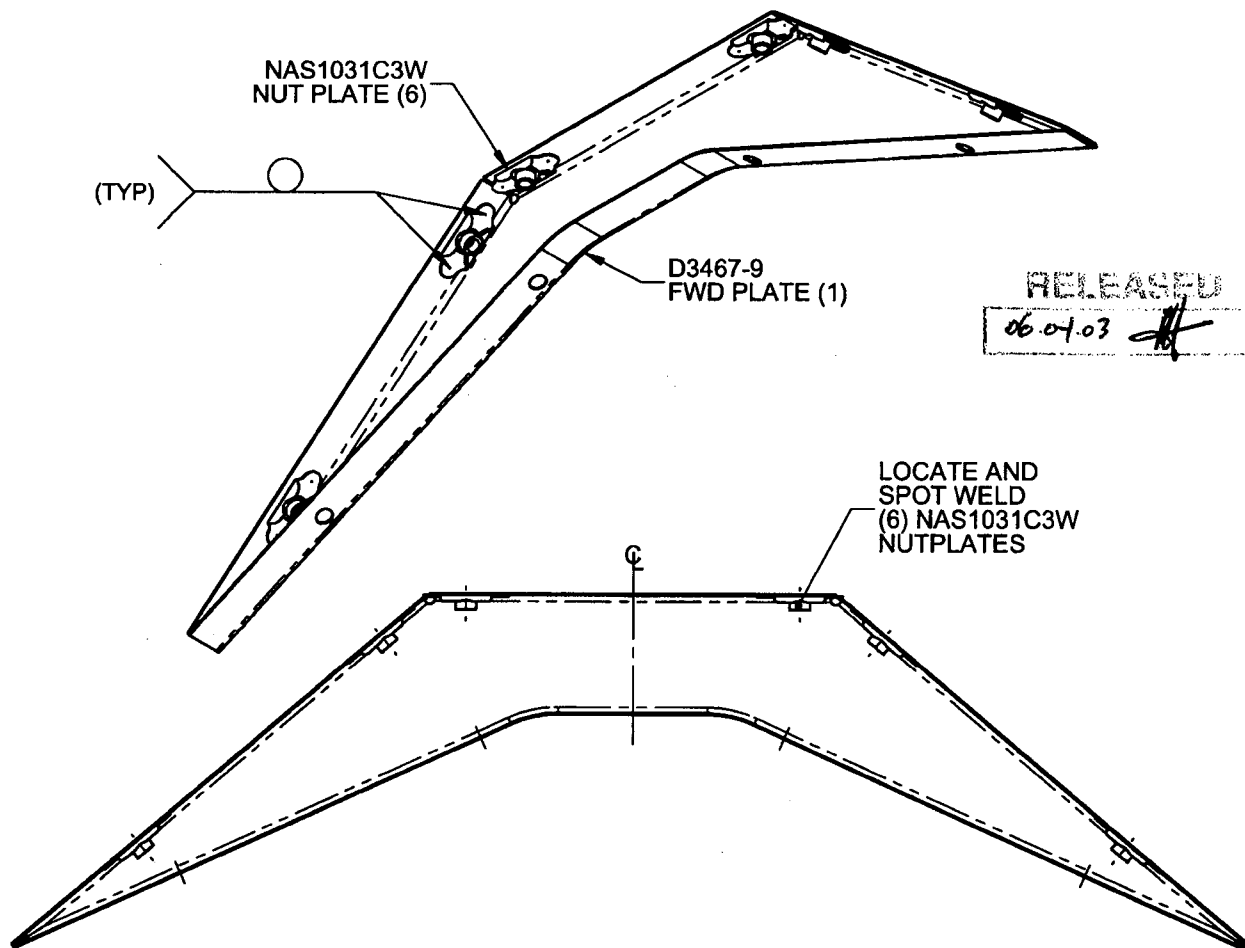
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| DATE 05.12.07 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |



| QTY -043 | P/N | DESCRIPTION |
|-------------|------------|--------------------|
| X | D3467-043 | FWD PLATE ASSEMBLY |
| 1 | D3467-9 | FWD PLATE |
| 6 | NAS1031C3W | NUT PLATE |

D3467-043 FWD PLATE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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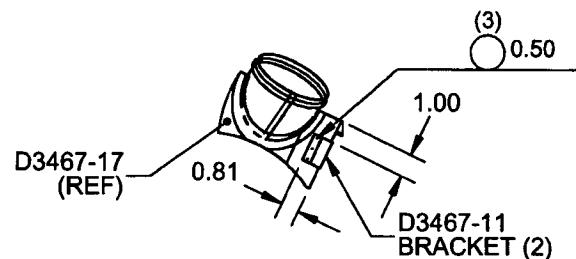
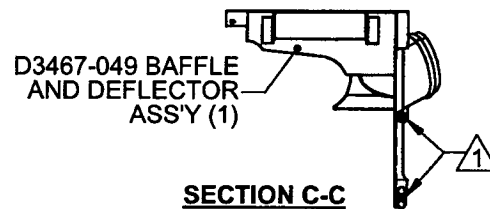
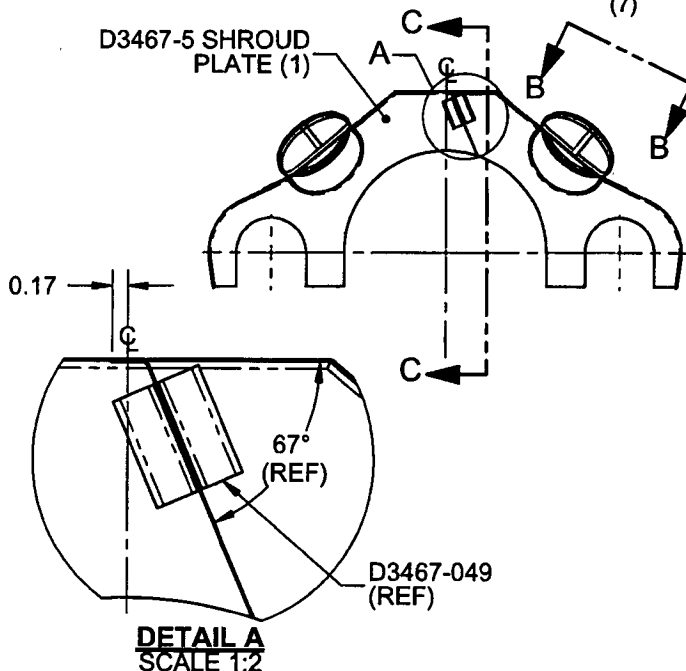
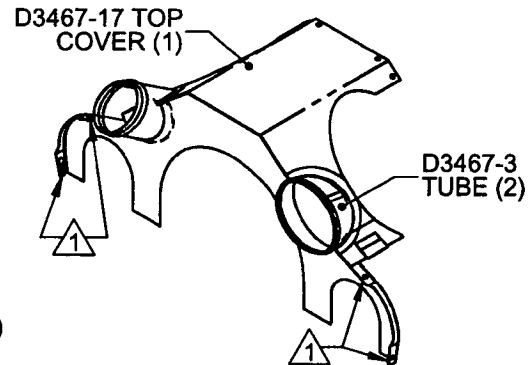
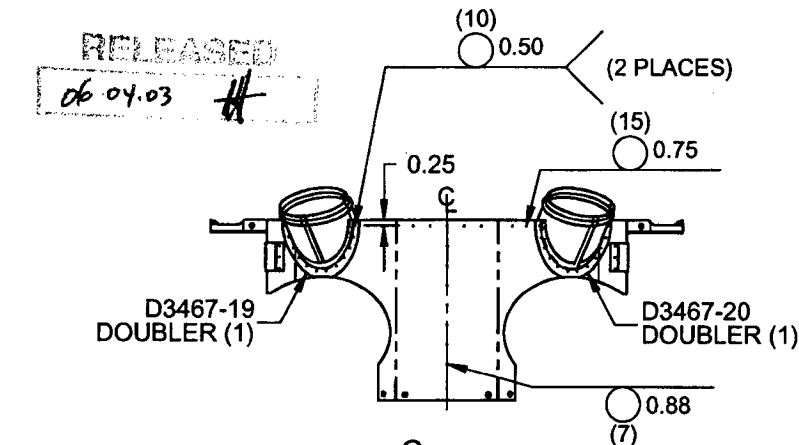
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| DATE 05.12.07 | | TITLE SHROUD ASSEMBLY | SHEET 3 OF 15 SCALE 1:8 |

RELEASED

06 04.03



VIEW B-B: WELDING D3467-11
D3467-047 NOT SHOWN FOR CLARITY
(2 PLACES)

D3467-045 AFT PLATE ASSEMBLY

NOTES:

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

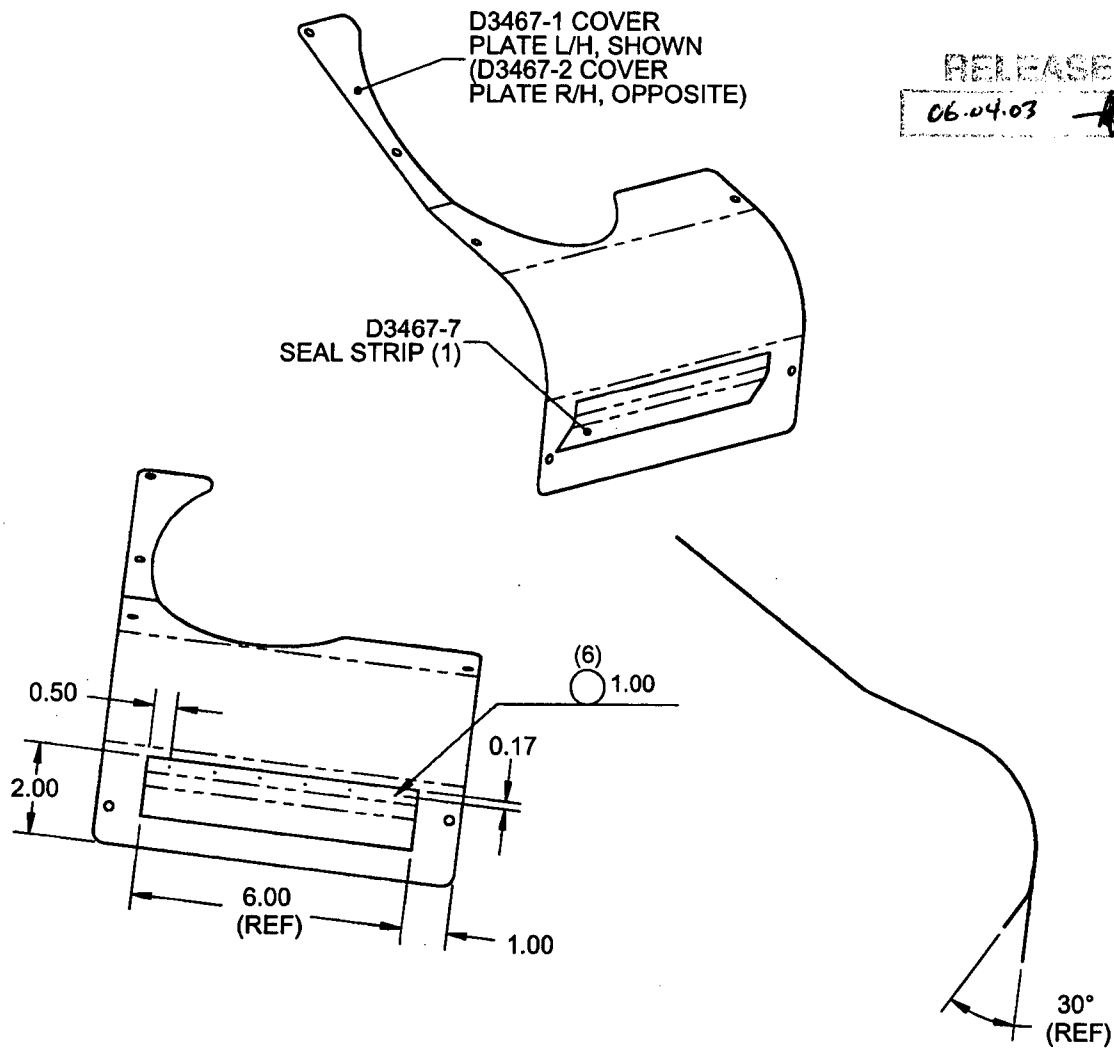
| QTY -045 | P/N | DESCRIPTION |
|-------------|------------|-------------------------------|
| X | D3467-045 | AFT PLATE ASSEMBLY |
| 1 | D3467-049 | BAFFLE AND DEFLECTOR ASSEMBLY |
| 2 | D3467-3 | TUBE |
| 1 | D3467-5 | SHROUD PLATE |
| 2 | D3467-11 | BRACKET |
| 1 | D3467-17 | TOP COVER |
| 1 | D3467-19 | DOUBLER |
| 1 | D3467-20 | DOUBLER |
| 4 | NAS1031C3W | NUT PLATE |

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| DATE 05.12.07 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |



D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

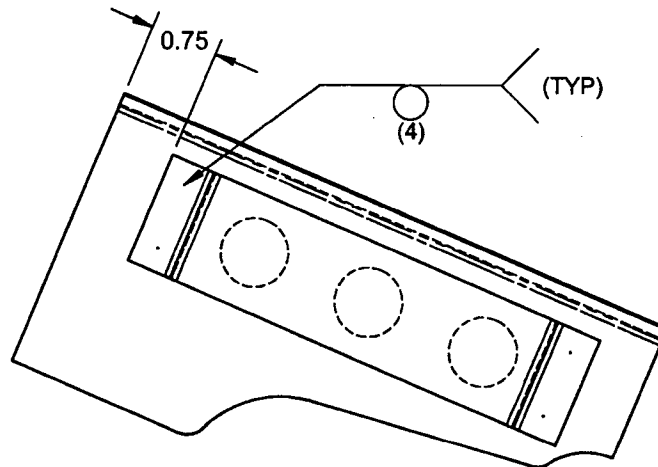
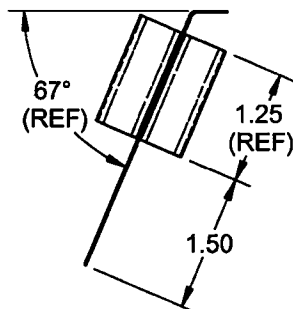
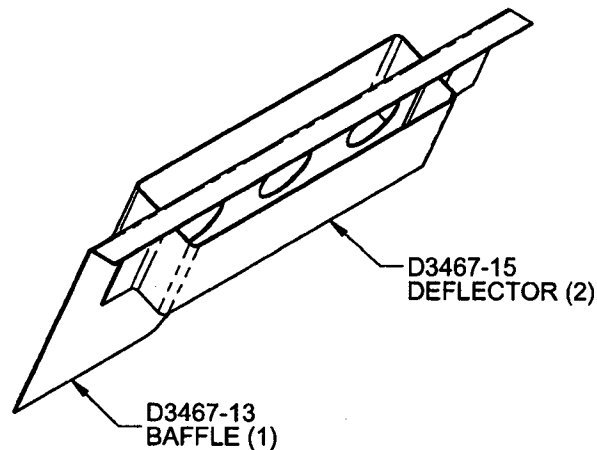
| QTY -047 | QTY -048 | P/N | DESCRIPTION |
|-------------|-------------|-----------|---------------------------|
| X | | D3467-047 | COVER PLATE ASSEMBLY, L/H |
| | X | D3467-048 | COVER PLATE ASSEMBLY, R/H |
| 1 | | D3467-1 | COVER PLATE, L/H |
| | 1 | D3467-2 | COVER PLATE, R/H |
| 1 | 1 | D3467-7 | SEAL STRIP |

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| DATE 05.12.07 | | TITLE SHROUD ASSEMBLY | SCALE 1:2 |



D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

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NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

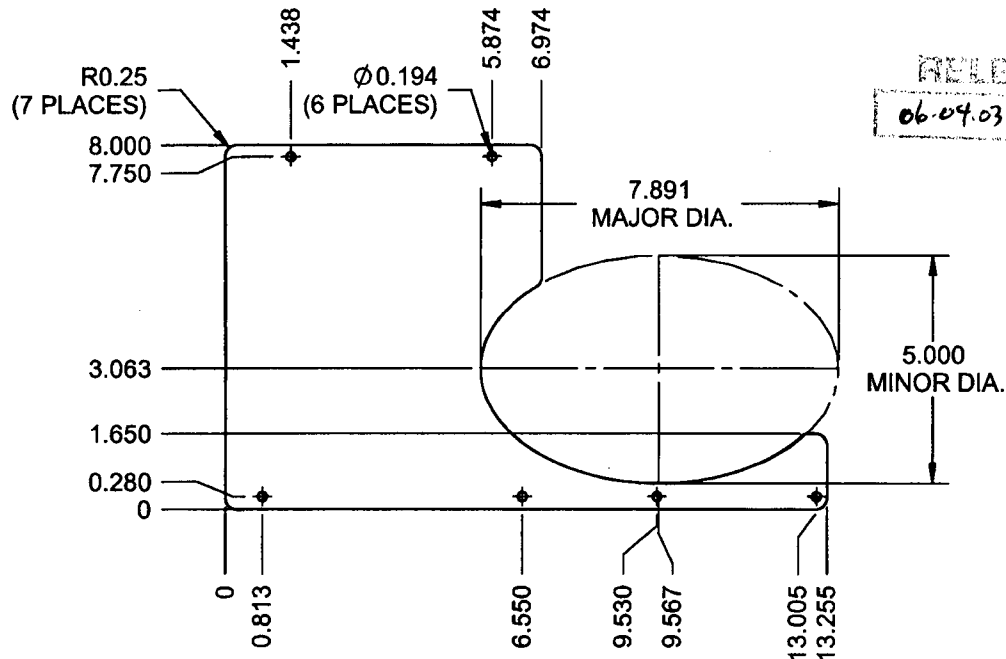
| QTY -049 | P/N | DESCRIPTION |
|-------------|-----------|-----------------------------|
| | D3467-049 | BAFFLE & DEFLECTOR ASSEMBLY |
| 1 | D3467-13 | BAFFLE |
| 2 | D3467-15 | DEFLECTOR |

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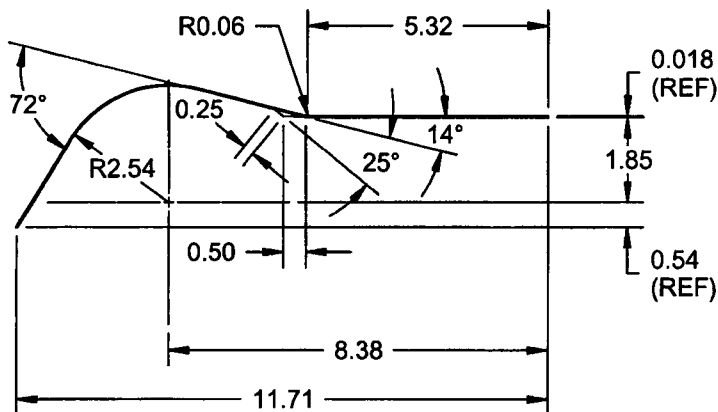
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| DATE 05.12.07 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |



D3467-1F COVER PLATE FLAT PATTERN



D3467-1 L/H COVER PLATE
D3467-2 R/H COVER PLATE (OPPOSITE)

D3467-1 L/H COVER PLATE ISOMETRIC VIEW,
D3467-2 R/H COVER PLATE (OPPOSITE)

SCALE 1:8
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NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

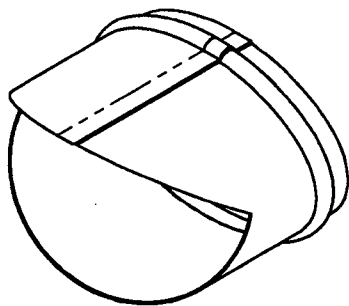
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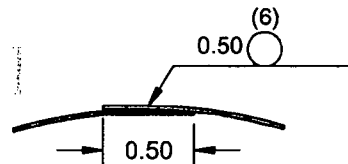
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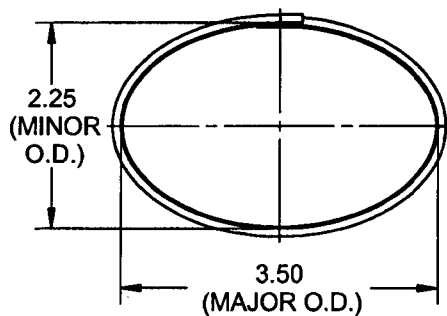
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| DATE 05.12.07 | TITLE SHROUD ASSEMBLY | | SCALE 1:2 |



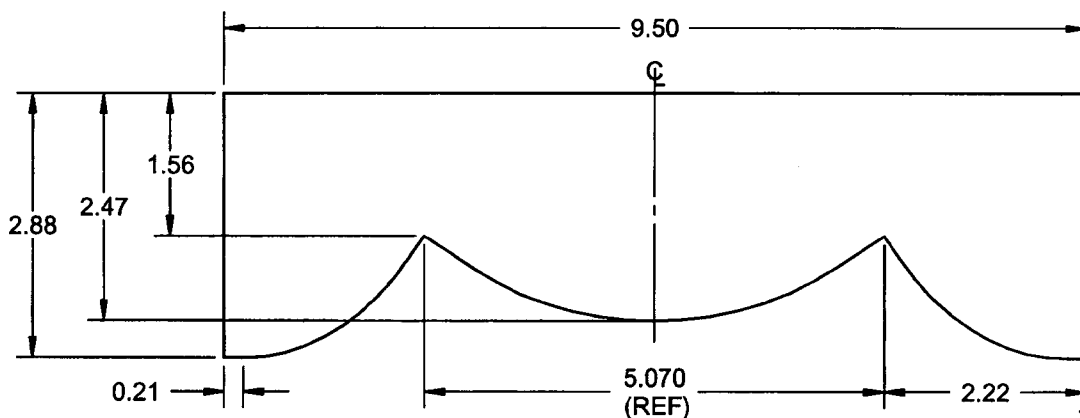
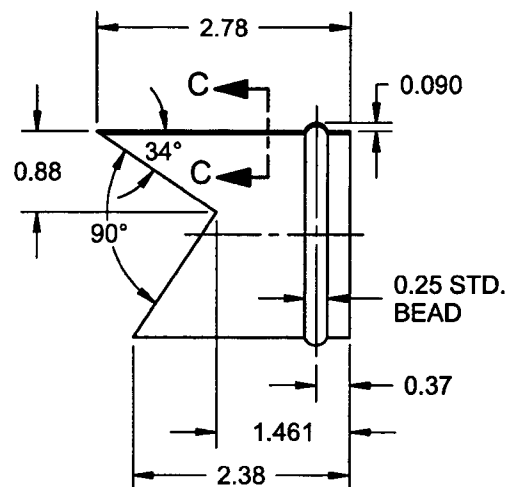
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06.04.03 *H*



SECTION C-C
SCALE 1:1



D3467-3 TUBE DETAIL



D3467-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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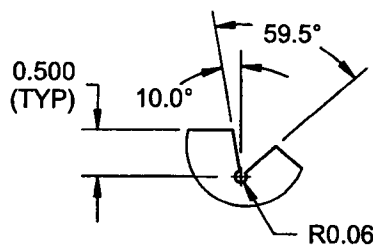
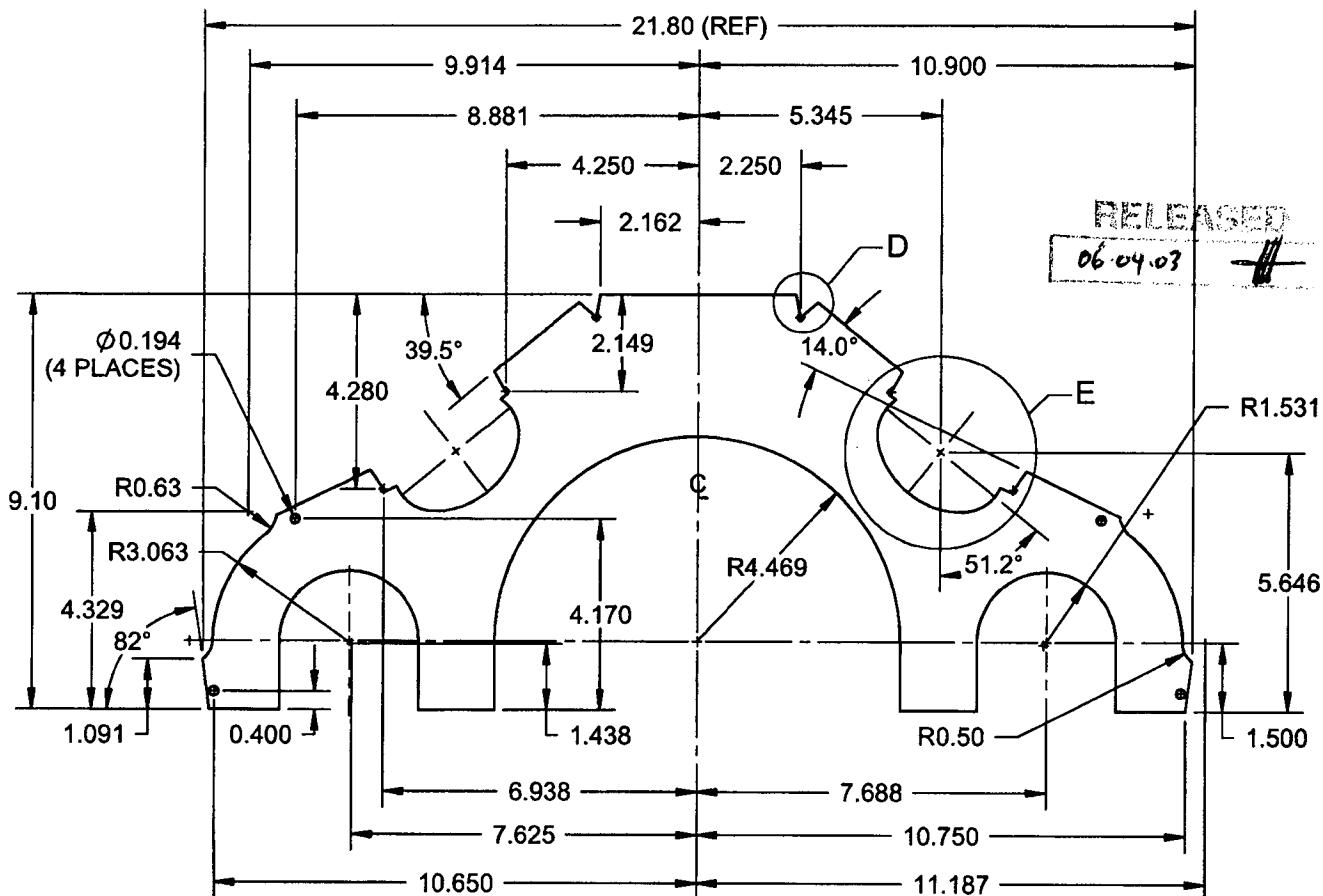
WORK ORDER
NO. **26950**

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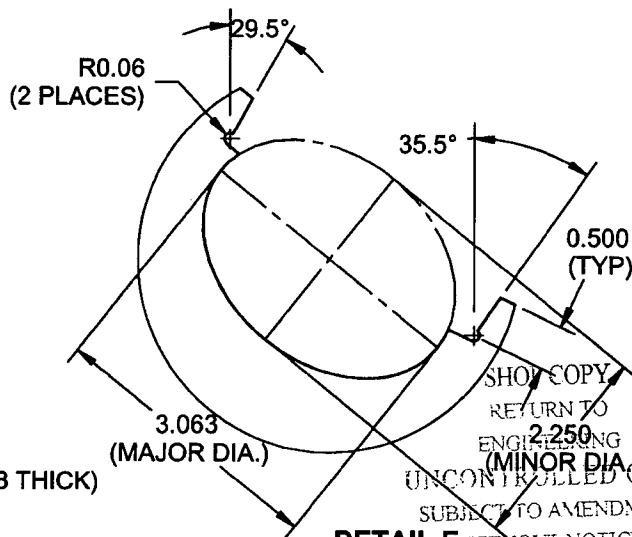
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| DATE 05.12.07 | | TITLE SHROUD ASSEMBLY | SCALE 1:8 |



DETAIL D
SCALE 1:2



DETAIL E
SCALE 1:2

D3467-5F AFT PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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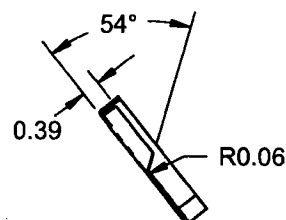
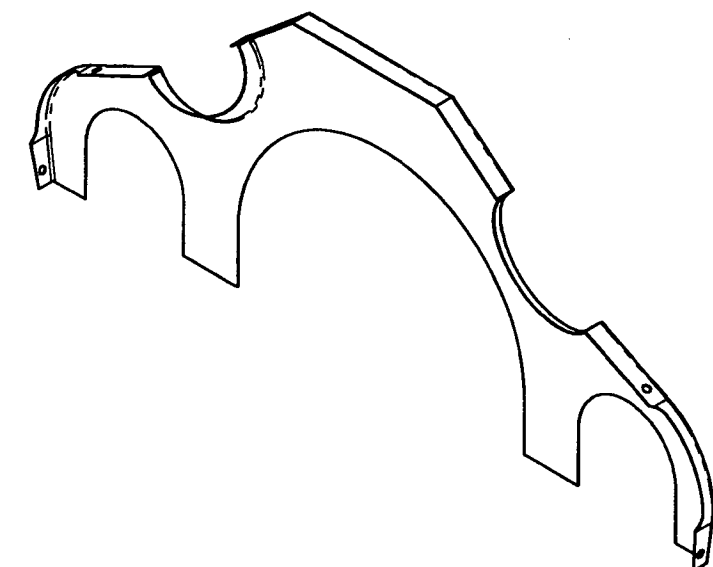
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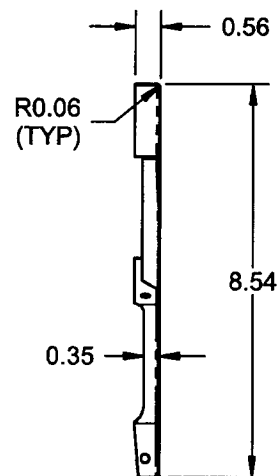
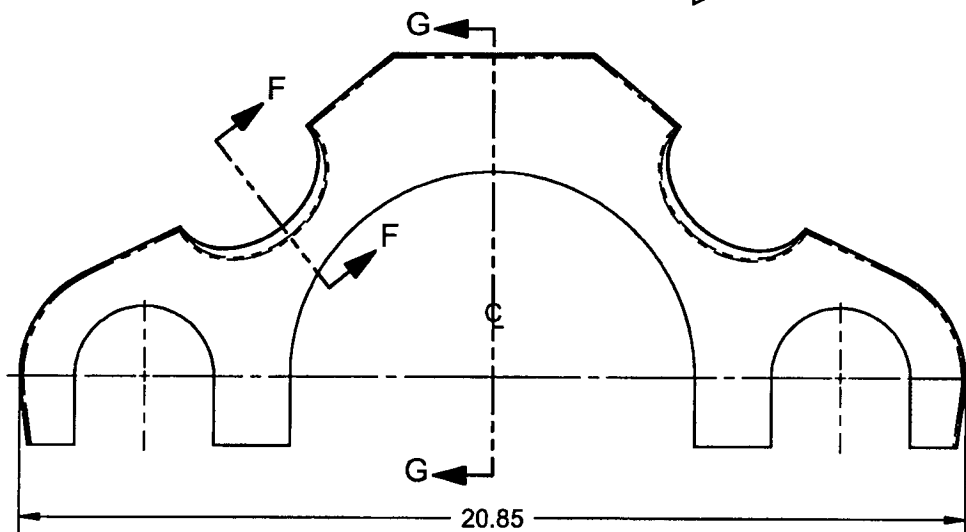
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| DATE 05.12.07 | TITLE SHROUD ASSEMBLY | | SCALE 1:4 |



SECTION F-F



SECTION G-G

D3467-5 AFT PLATE BENDING DETAIL

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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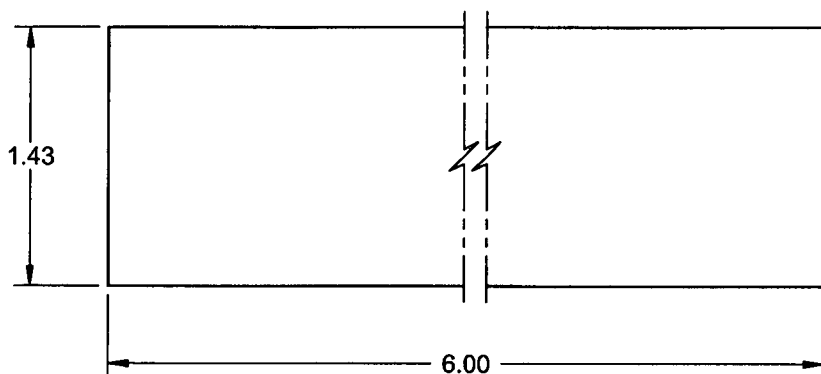
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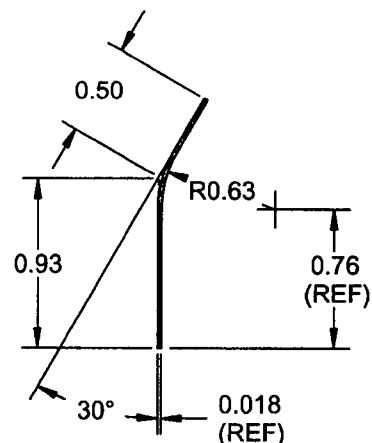


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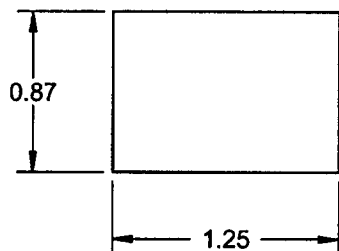
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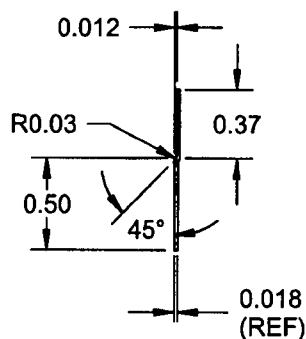
**D3467-7F SEAL STRIP
FLAT PATTERN**



**D3467-7 SEAL STRIP
BENDING DETAIL**



**D3467-11F BRACKET
FLAT PATTERN**



**D3467-11 BRACKET
JOGGLE DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

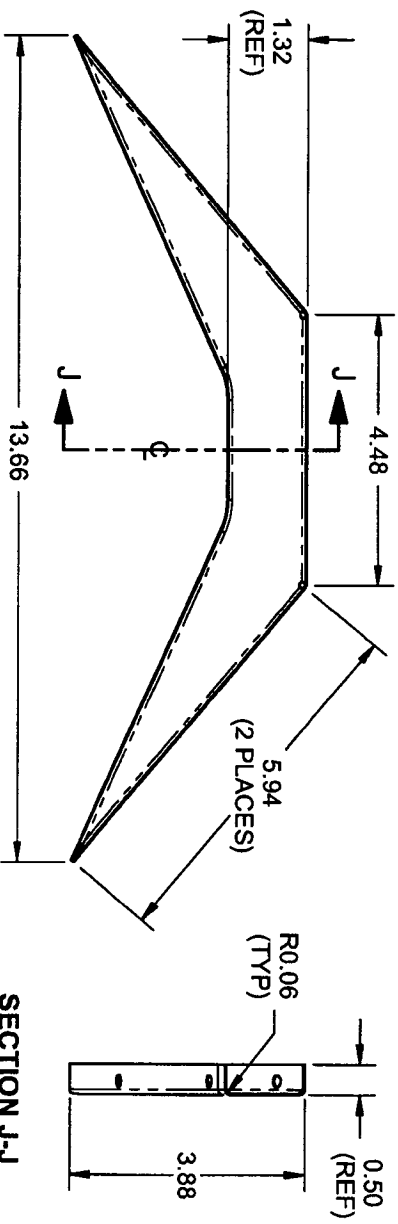
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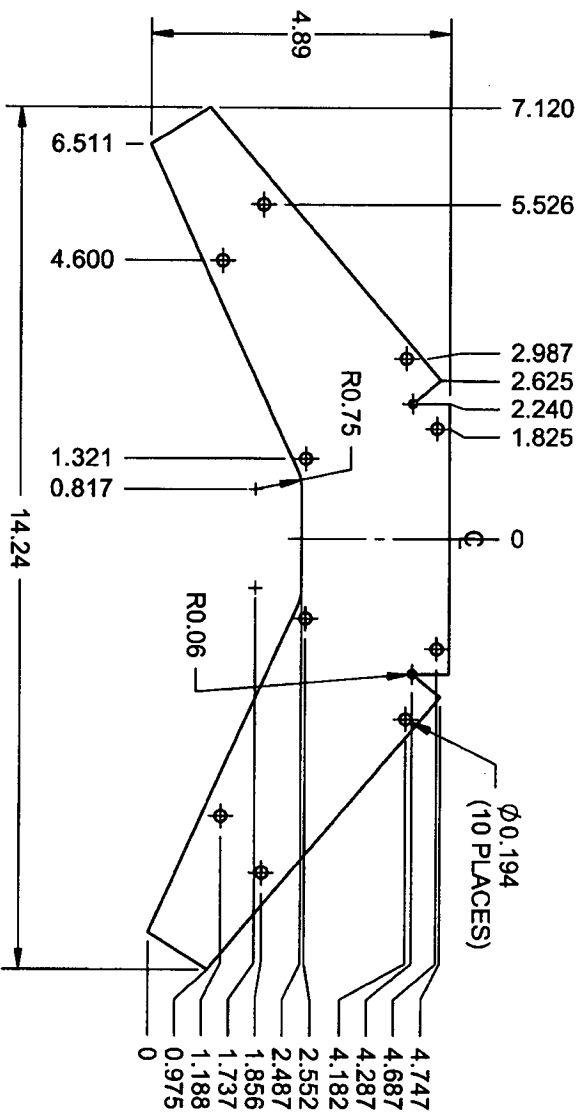
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D3467-9 FWD PLATE BENDING DETAIL



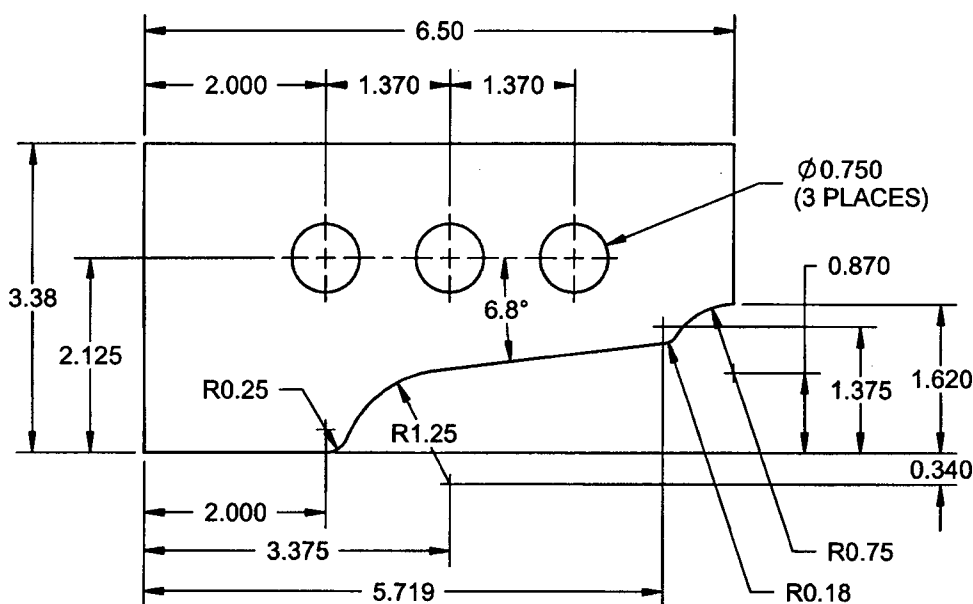
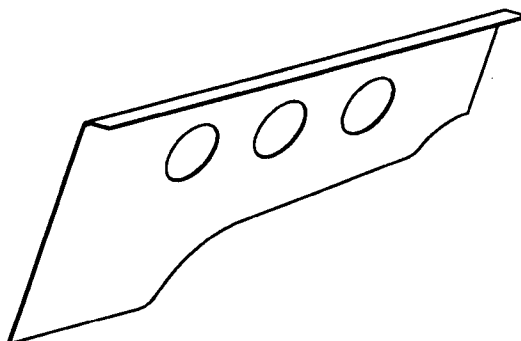
D3467-9F FWD PLATE FLAT PATTERN

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
 - 2) PART IS SYMMETRICAL ABOUT CENTER LINE
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
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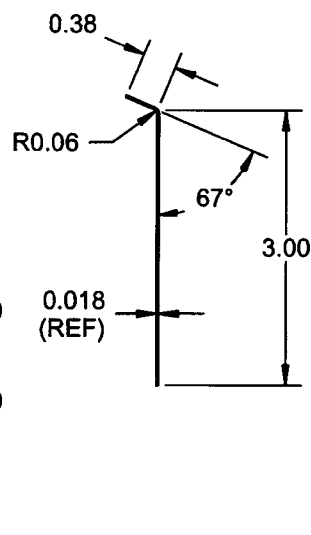


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**D3467-13F BAFFLE
FLAT PATTERN**



**D3467-13 BAFFLE
BEND DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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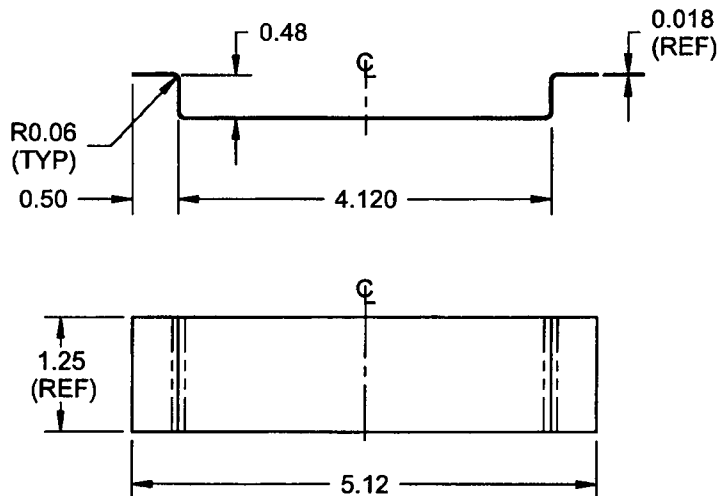
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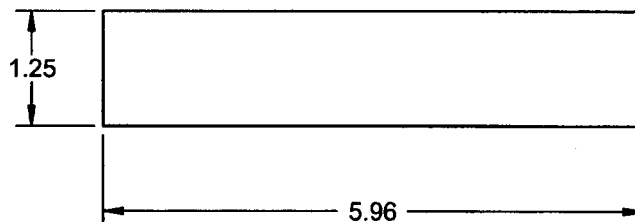


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D3467-15 DEFLECTOR BENDING DETAIL



D3467-15F DEFLECTOR FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

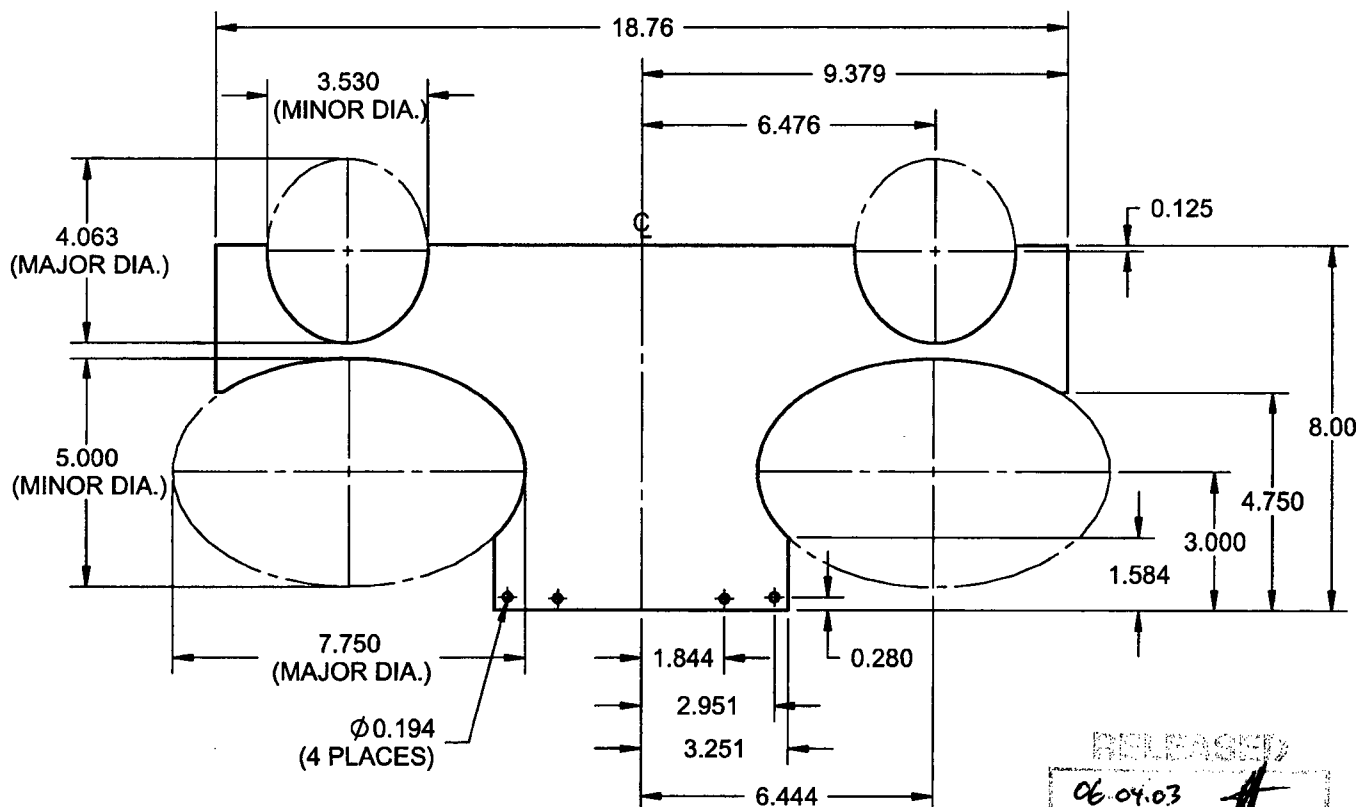
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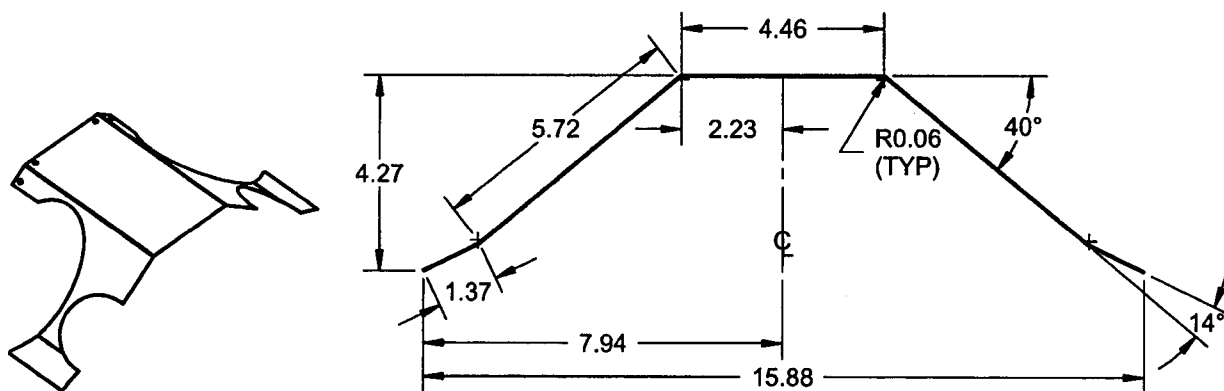
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| DATE 05.12.07 | | TITLE SHROUD ASSEMBLY | SCALE 1:4 |



D3467-17F TOP COVER FLAT PATTERN



D3467-17 TOP COVER BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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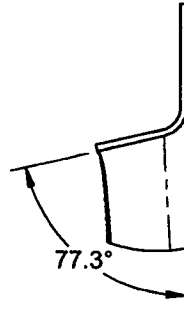
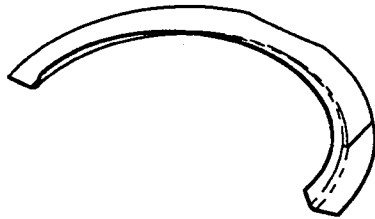
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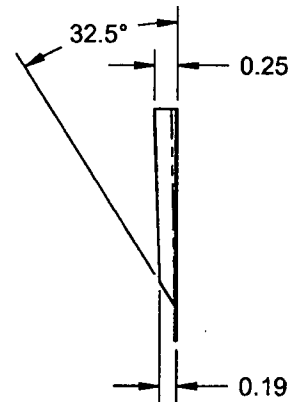
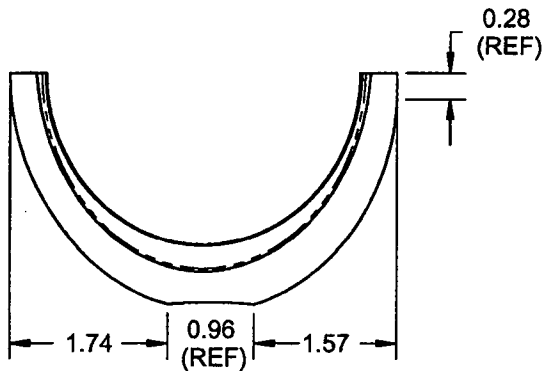
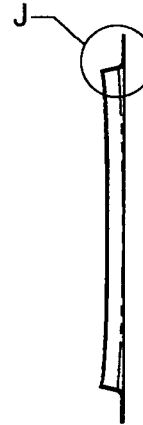
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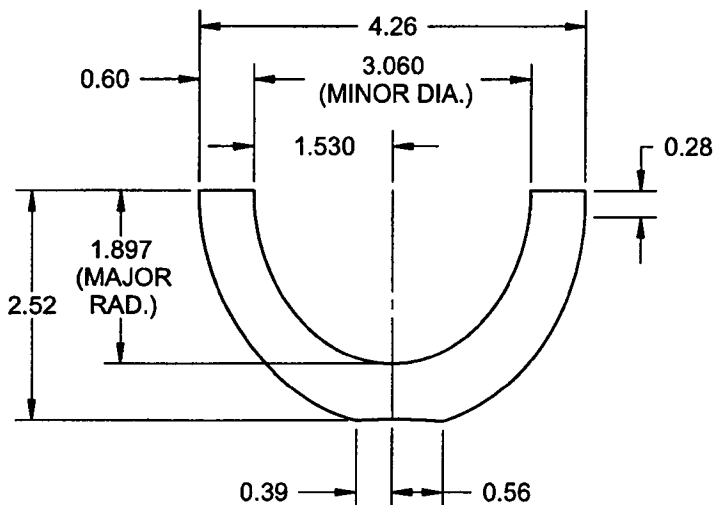
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DETAIL J
SCALE 1:2



D3467-19 DOUBLER, L/H SHOWN
D3467-20 DOUBLER, R/H OPPOSITE



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D3467-19F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER
MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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